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IS 6237 (1971): Handloom Cotton Cloth for Plaster of Paris  
Bandages and Cut Bandages [TXD 8: Handloom and Khadi]



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“Knowledge is such a treasure which cannot be stolen”



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IS : 6237 - 1971

# *Indian Standard*

## SPECIFICATION FOR HANDLOOM COTTON CLOTH FOR PLASTER OF PARIS BANDAGES AND CUT BANDAGES

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INDIAN STANDARDS INSTITUTION  
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG  
NEW DELHI 110002

# Indian Standard

## SPECIFICATION FOR HANDLOOM COTTON CLOTH FOR PLASTER OF PARIS BANDAGES AND CUT BANDAGES

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The Andhra Handloom Weavers Co-operative  
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The Tamilnadu ( Madras State ) Handloom  
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Textiles Committee, Bombay  
Government of Uttar Pradesh

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*Secretary*

SHRI O. P. KHULLAR

Assistant Director ( Tex ), ISI

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\*Shri D. S. V. Iyer was Chairman for the meeting in which this standard was finalized.

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# *Indian Standard*

## SPECIFICATION FOR HANDLOOM COTTON CLOTH FOR PLASTER OF PARIS BANDAGES AND CUT BANDAGES

### 0. FOREWORD

**0.1** This Indian Standard was adopted by the Indian Standards Institution on 3 September 1971, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

**0.2** The cloth for plaster of paris 'POP' bandages is a woven cotton fabric dressed with starch and china clay, and is used in conjunction with plaster of paris.

**0.3** This specification is related to the requirements of official agencies in this field and, therefore, is based on IND/MED/TC/0179 'Specification for bandages for plaster of paris' issued by the Ministry of Defence, Government of India.

**0.4** For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS : 2-1960\*. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

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### 1. SCOPE

**1.1** This standard prescribes the constructional details and other requirements of two varieties of handloom cotton cloth for plaster of paris 'POP' bandages and cut bandages.

### 2. MANUFACTURE

**2.1 Yarn** — The yarn used in the manufacture of bandages shall be machine spun. It should be reasonably free from defects and such that the bandages produced comply with the requirements of this standard.

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\*Rules for rounding off numerical values (*revised*).

## 2.2 Cloth

2.2.1 The fabric shall be clean and reasonably free from weaving defects.

2.2.2 The fabric shall be bleached to a good white.

2.2.3 The fabric shall be dressed with starch and china clay.

2.2.4 The dressed bandage shall not dust off.

## 3. CONSTRUCTIONAL PARTICULARS

3.1 The constructional particulars and other details of cotton cloth for 'POP' bandages are given in Table 1 for guidance of manufacturers.

**TABLE 1 REQUIREMENTS OF HANDLOOM COTTON CLOTH FOR PLASTER OF PARIS BANDAGES**

SL No.	CHARACTERISTIC	REQUIREMENT		METHOD OF TEST
		Variety 1	Variety 2	
i)	Weave	Plain	Leno	Visual
ii)	Approximate count of yarn (for manufacturer's guidance only):			
	a) Warp	18 tex to 21 tex (28s to 32s)	13 tex to 15 tex (40s to 44s)	—
	b) Weft	18 tex to 21 tex (28s to 32s)	16 tex to 18 tex (32s to 36s)	—
iii)	Threads per dm, <i>Min</i> :			IS : 1963 - 1969*
	a) Ends	130	210	
	b) Picks	75	90	
iv)	Weight (g/m <sup>2</sup> ), <i>Min</i>	40	50	IS : 1964 - 1970†
v)	Length, m	20 or as ordered	20 or as ordered	IS : 1954 - 1969‡
	<i>Tolerance</i>	± 5 cm	± 5 cm	
vi)	Width, cm	60 or as ordered	60 or as ordered	IS : 1954 - 1969‡
	<i>Tolerance</i>	± 1.5 cm	± 1.5 cm	

\*Method for determination of threads per decimetre in woven fabrics (*first revision*).

†Methods for determination of weight per square metre and weight per linear metre of fabrics (*first revision*).

‡Method for determination of length and width of fabrics (*first revision*).

## 4. REQUIREMENTS

4.1 The requirements of cut bandages are given in Table 2.

TABLE 2 REQUIREMENTS OF PLASTER OF PARIS BANDAGES

( Clause 4.1 )

Sl No.	CHARACTERISTIC	REQUIREMENT	METHOD OF TEST
i)	Length, m <i>Tolerance</i>	3 or 5 $\pm 5$ cm	IS : 1954 - 1969*
ii)	Width, cm <i>Tolerance</i>	7.5, 10, 15 or 20 $\pm 0.5$ cm	IS : 1954 - 1969*
iii)	Dressing content, percent	20, <i>Min</i> 30, <i>Max</i>	IS : 1383 - 1960†
iv)	Ash content, percent.	7.5, <i>Max</i>	IS : 199 - 1957‡

\*Method for determination of length and width of fabrics.

†Method for determination of scouring loss in grey and finished cotton textile materials.

‡Methods for determination of moisture, total size or finish, ash and fatty matter in grey and finished cotton textile materials (*revised*).

## 5. PACKING

**5.1** Unless otherwise specified, the bandage cloth shall be packed in bales as given in **5.1.1** to **5.1.5**. Press packing of bales shall be carried out wherever feasible.

**5.1.1** The bandage cloth suitably folded and placed one over the other, shall be wrapped with two layers of kraft paper (*see* IS : 1397 - 1967\*) to form a packet.

**5.1.2** The cut bandages shall be made into rolls. Each roll shall be neatly and securely wrapped with blue or brown paper wrapping around its circumference only leaving the ends uncovered.

**5.1.2.1** The number of packets per bale shall be 150 in case of bandages having width of 7.5 or 10 cm and 75 in case of bandages of 15 or 20 cm width.

**5.1.3** The packets, as obtained above (*see* **5.1.1** and **5.1.2**) shall be wrapped with the following materials:

- a) One layer of polyethylene film of at least 40 microns thickness (*see* Grade 123 of IS : 2508 - 1963†)

or

One layer of waterproof paper (*see* IS : 1398 - 1968‡), and

- b) One layer of jute cloth heavy cee (*see* IS : 3751 - 1966§).

\*Specification for kraft paper (*first revision*).

†Specification for low density polyethylene films.

‡Specification for packing paper, waterproof, bitumen-laminated (*first revision*).

§Specification for heavy cee cloth.

**5.1.4** The outer layer of the bale, that is, jute cloth, shall be securely sewn with at least 10 stitches/dm. Slats of timber approximately 80 mm wide and 12 mm thick, shall be placed lengthwise along the edges of the bale and 3 steel baling hoops shall be used to tighten the bale and hold the slats in position. The hoops shall be machine sealed or made firm by rivets.

**5.1.5** Unless otherwise specified, the gross weight of the bale shall not exceed 40 kg.

## **6. MARKING**

**6.1** Each packet shall have a label with the following information pasted:

- a) Name of the material,
- b) Manufacturer's name and address,
- c) Month and year of manufacture,
- d) Width in centimetres and length in m of the piece, and
- e) Number of bandages.

**6.1.1** The packets may also be marked with the ISI Certification Mark.

NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act and the Rules and Regulations made thereunder. The ISI Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by ISI and operated by the producer. ISI marked products are also continuously checked by ISI for conformity to that standard as a further safeguard. Details or conditions under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution.

**6.2** Each bale shall be legibly marked with the following:

- a) Name of the material;
- b) Quantity packed;
- c) Month and year of manufacture;
- d) Manufacturer's name, initials or trade-mark; and
- e) Gross weight of the bale.

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